

Date: Tuesday, 06/01/2009 10:04:47 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 44398  
 Estimate Number : 11110  
 P.O. Number :  
 This Issue : 06/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D33047  
 Drawing Number : D3304 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 First Issue : / / Type : SMALL /MED FAB  
 Material :  
 Due Date : 20/01/2009 Qty: 20 Um: Each  
 Previous Run : 42231  
 Written By :  
 Checked & Approved By : JD 09.01.06  
 Comment : Est A 04.09.07 New issue KJ/JLM  
 Est B 08.08.06 waterjet EC verified by DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.0683 sf(s)/Unit Total : 1.3650 sf(s)

304/316 .040 Sheet

batch: 110076

189-2-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3304

Dwg Rev: B

Prog Rev: B

189-2-23

2-Deburr if necessary

11

M-1 04/02/23

21

21X

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



189-2-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/02/23 (x21) counters

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr

2-Form as per Dwg D3304

3-Tumble

SB 09/03/09 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:47 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44398

Part Number: D33047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*70902-10 (21)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: Carl L.

*SS 09/03/10 (21)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/10*

Job Completion



*MF 09-03-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44398
Description: Bracket		Part Number: D3304-7
Inspection Dwg: D3304	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	X			
Ø0.219	+0.005/-0.001	.222	X			
0.375	+/-0.010	.375	X			
0.500	+/-0.010	.502	X			
1.500	+/-0.010	1.499	X			
0.375	+/-0.010	.377	X			
0.937	+/-0.010	.938	X			
2.000	+/-0.010	2.005	X			
0.375	+/-0.010	.373	X			
2.250	+/-0.010	2.254	X			
3.875	+/-0.010	3.871	X			
1.000	+/-0.010	1.004	X			
1.125	+/-0.010	1.127	X			
0.040	+/-0.010	.040	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-23	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.24	New Issue	KJ/DD	

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

WED

DRAWN BY R

DRAWING NO.

D52

REV. B  
SHEET 1 OF 4

05.07.15

TUBE ASSEMBLY

1:5

A

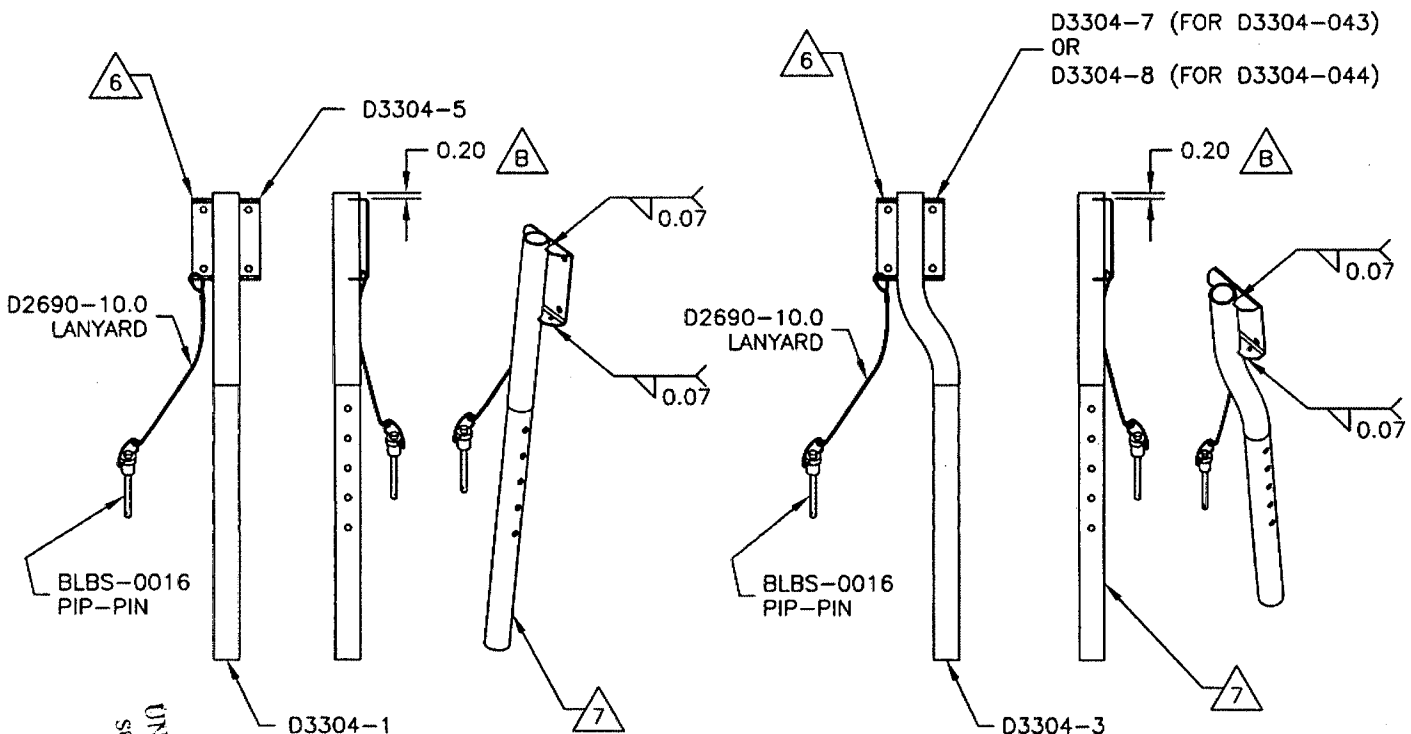
04.08.18

NEW ISSUE



05.07.15

UPDATE DIMENSIONS; ADD D3304-7/-8



**D3304-044 TUBE ASSEMBLY (SHOWN)**  
**D3304-043 OPPOSITE**

**D3304-041 TUBE ASSEMBLY**

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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WORK ORDER  
NO. 14318

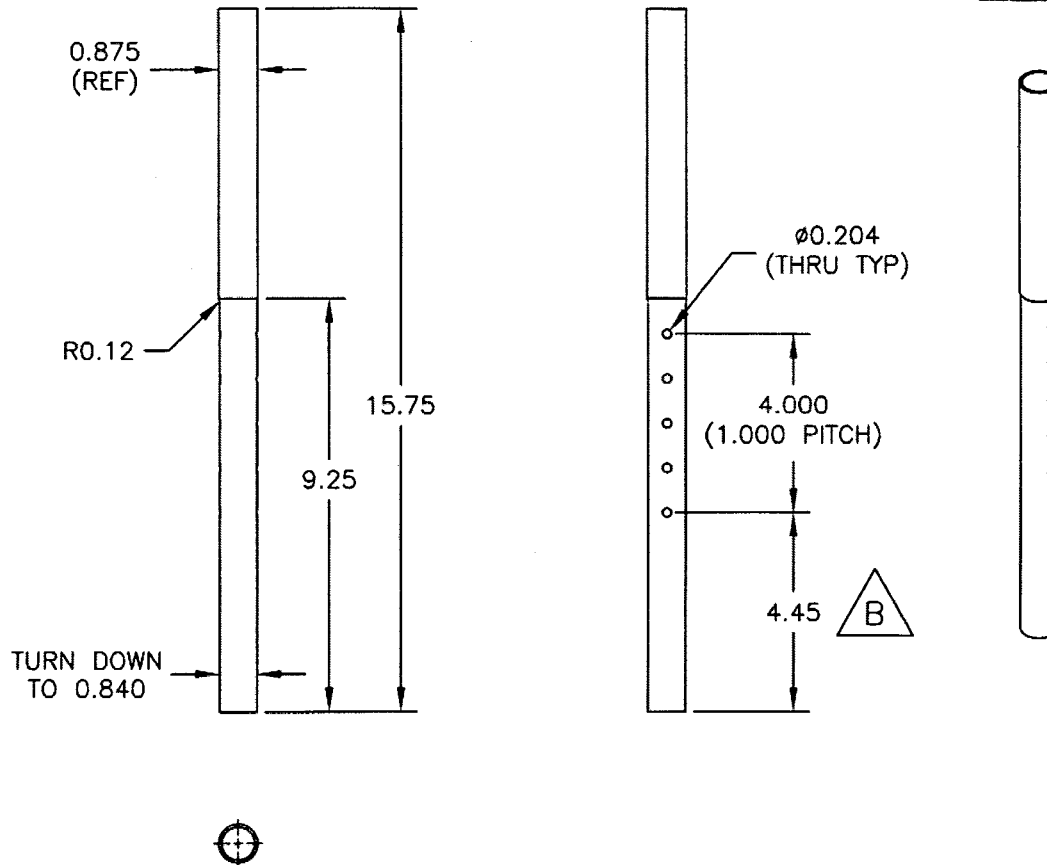
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25-08-11

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**RELEASED**  
05.08.11 #5**D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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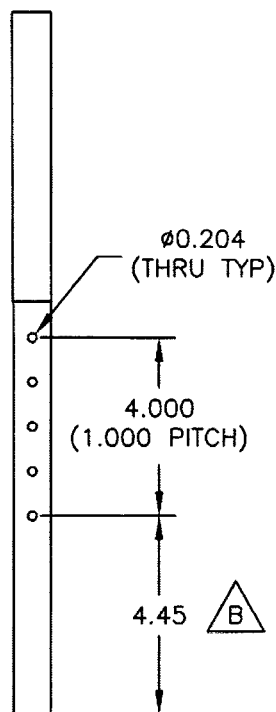
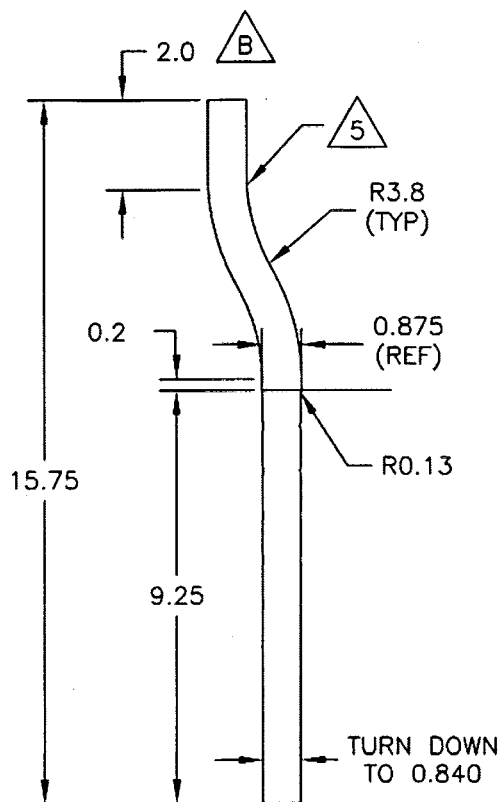
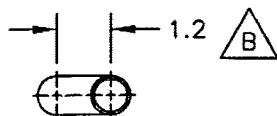
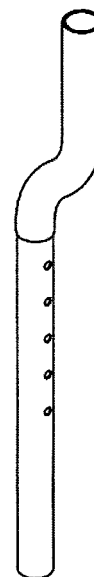
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**RELEASED**  
05-08-11 *[Signature]***D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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WORK ORDER  
NO. 144398

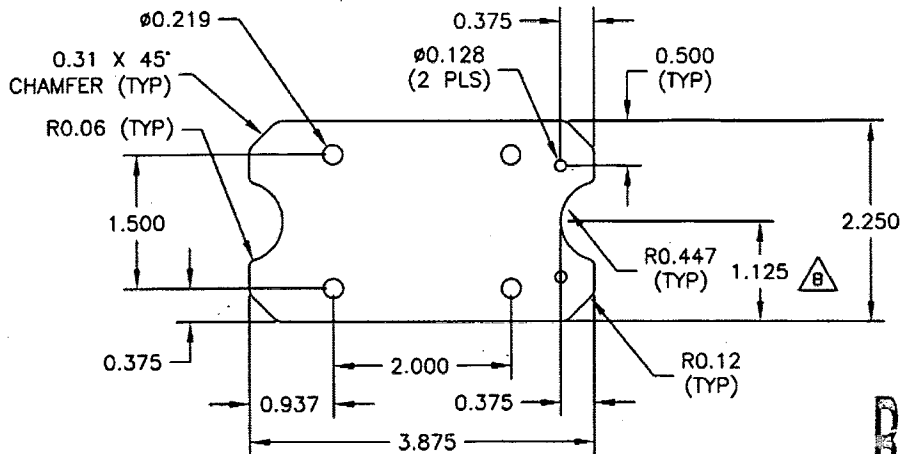
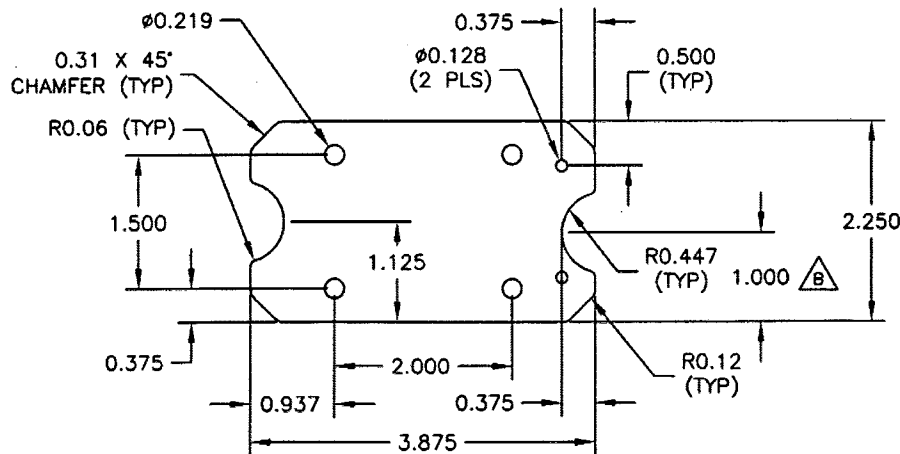
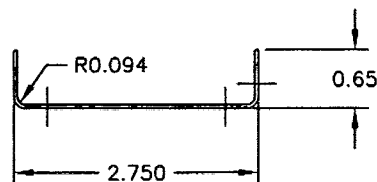
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2

**D3304-5 FLAT PATTERN****RELEASED**  
05.08.11**D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET  
D3304-8 OPPOSITE****WORK COPY  
RETURN TO  
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SUBJECT TO AMENDMENT****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA) WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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